

# DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 REV. 4

REF. CANADIAN STC: SH03-6

REF. FAA STC: SR01742NY

REF. EASA STC: 10016828

## PURPOSE

To increase paint adhesion on D412-596-203 Crosstubes.

## CHANGE

When refinishing D412-596-203 Crosstubes, it is recommended to prepare the metal surface with a pre-treatment prior to applying the primer/paint:

The substrate must be free of contaminants (dirt, oil, grease, etc) prior to application of the pre-treatment. It is recommended to use Axalta 13205S Aluminum Cleaner, which is effective on the stainless steel substrate of the crosstube.

Apply Axalta Metalok 230S Adhesion Promoter or DOD-P-15328D Wash Primer per manufacturer's instruction to the clean metal surface.

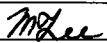


After application of the pre-treatment, the crosstube should be refinished with MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 16.04.01  
CERT. NO.: SH03-6  
ISSUE NO.: 4

A	NEW ISSUE	CP	16.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9743	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		FINISH PRE-TREATMENT	NTS
DATE	16.04.01	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	